

Date: Monday, 25/05/2009 12:48:53 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HINGE BRACKET
Job Number :	48197		
Estimate Number :	12543		
P.O. Number :		Part Number :	D35381
This Issue :	25/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3538 REV.A
First Issue :	11	Project Number :	10254N/A
Previous Run :	46753	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	12/06/2009
Written By :		Qty:	20
Checked & Approved By :	JUD 09.05.25	Um:	Each
Comment :	Est Rev:A New Issue 06-10.03 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
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Comment: Qty.: 0.1995 f(s)/Unit Total : 3.9900 f(s)
 6061_T6 Bar 1.250" x 1.250
 Batch: M110001

mk 09/05/29

(20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 1.500" long

mk 09/05/29

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: 1-Machine as per Folio FA651 and Dwg D3538

2-Deburr

SL 09/06/01

Pro

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 09/06/01

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL 09/06/01

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

MD 09/06/02

(x19)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3538-1 PAR #: N/A Fault Category: Prod / Machine / Parts NCR: Yes No DQA: D Date: 09/06/04
D35-600-1141/1142
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/06/04

NCR: <u>48197</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/06/04</u>	<u>3</u>	<u>- 1 part hole is off</u> <u>- operator hole wrong</u> <u>original</u> <u>RC: operator error.</u>	<u>[Signature]</u> <u>09/06/04</u>	<u>Scrap, destroy no replace.</u>	<u>SL</u> <u>09/06/04</u>	<u>[Signature]</u> <u>09/06/04</u>	<u>[Signature]</u> <u>09/06/04</u>	<u>[Signature]</u> <u>09/06/04</u>

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 12:48:53 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 48197

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



m111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:45

OVEN TEMPERATURE:

320°

FINISH TIME:

12:15

FL 09/06/02

19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/06/02

19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 111

9/6/03

19

SEP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/03

Job Completion



U 09.06.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48197
Description: Hinge Bracket		Part Number: D3538-1
Inspection Dwg: D3538	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.751	✓			
0.375	+/-0.010	.376	✓			
0.241	+/-0.010	.242	✓			
0.830	+/-0.010	.830	✓			
Ø0.172	+0.005/-0.001	.175	✓			
Ø0.400	+0.006/-0.001	.400	✓			
0.031	+/-0.010	.028	✓			
1.31	+/-0.030	1.313	✓			
0.375	+/-0.010	.375	✓			
0.99	+/-0.030	.988	✓			
0.125	+/-0.010	.121	✓			
R0.19	+/-0.030	.19	✓			
0.083	+/-0.010	.084	✓			
93°	+/-0.5°	93°	✓			
0.674	+/-0.010	.673	✓			
R0.38	+/-0.030	.38	✓			
Ø0.172	+0.005/-0.001	.173	✓			

Measured by:	JL
Date:	09/06/01

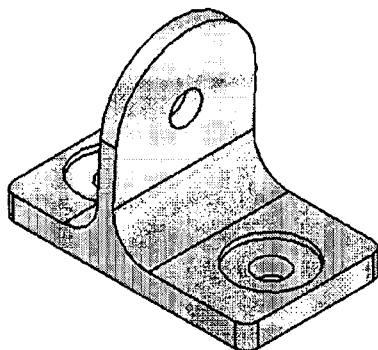
Audited by:	SP
Date:	09/06/01

Prototype Approval:	N/A
Date:	N/A

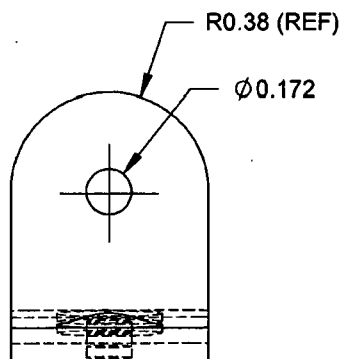
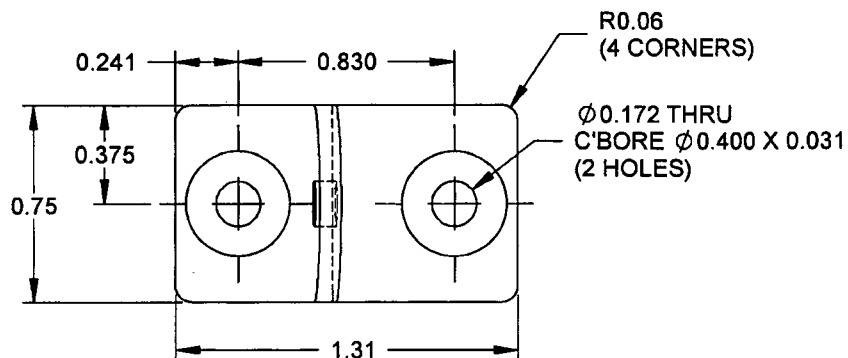
Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	SP



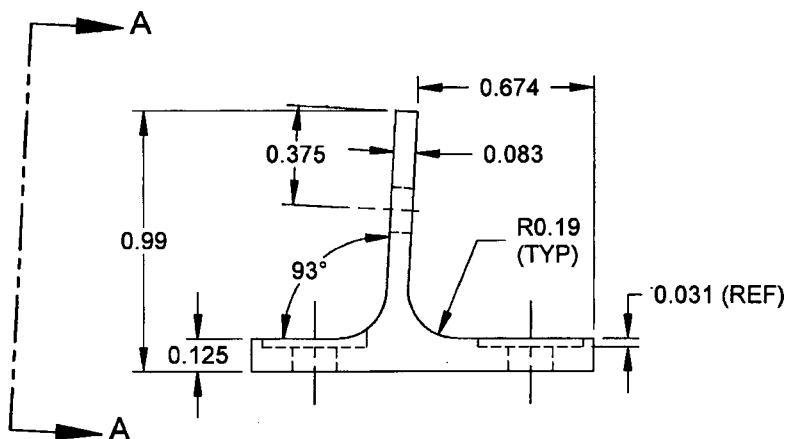
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	



RELEASED
06.10.13



AUXILIARY VIEW A



D3538-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

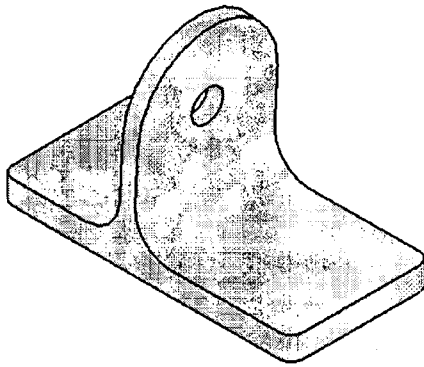
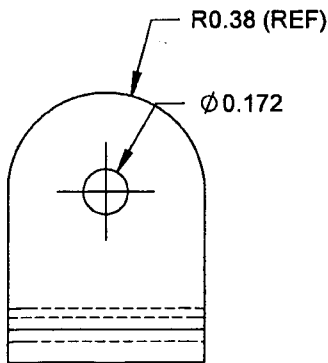
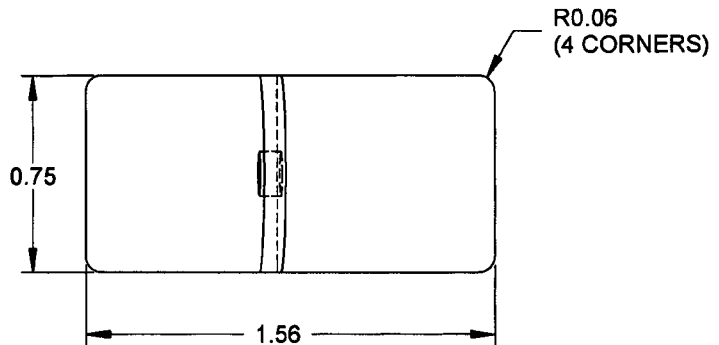
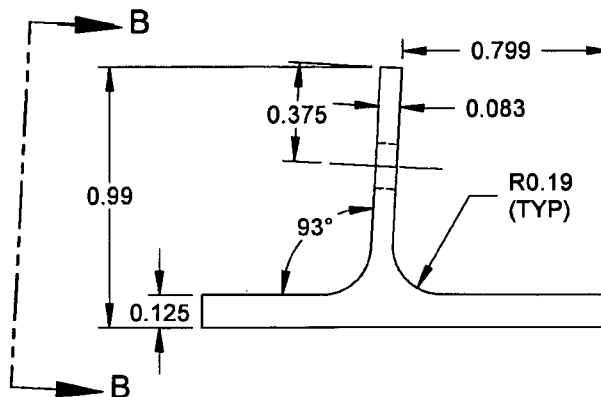
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DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1

**RELEASED**
06.10.13**AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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